



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB23007615
Job Sheet 186978



Part No: RB23007615

Job Qty: 8 pcs

Part Name: Power Turbine Support Cleaning C-30 & C-47



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/23/18

Job Tracking No:

Due Date: 1/11/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB23007615 REV B IPP REV A 18.02.20 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	8 pcs	1/11/19		0.00	0.00	Small Fab - 1		MLC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	8 pcs	1/11/19		0.00	0.00	QC 5 - 10		DAS 58 FEB 13 2019 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	8 pcs	1/11/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S153384



Part: RB23007615

Job No: 186978

Serial No/Batch: S153384

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 02/13/19

					Packaging 3 - 7 - B4B					
					Packaging 3 - 8 - B4B					
					Packaging 3 - 9 - B4B					
					Packaging 3 - 10 - B4B					
					Packaging 3 - 11 - B4B					
					Packaging 3 - 12 - B4B					
					Packaging 3 - 13 - B4B					
					Packaging 3 - 14 - B4B					
					Packaging 3 - 15 - B4B					
					Packaging 3 - 16 - B4B					
					Packaging 3 - 17 - B4B					
					Packaging 3 - 18 - B4B					
					Packaging 3 - 19 - B4B					
					Packaging 3 - 20 - B4B					
					Packaging 3 - 21 - B4B					
					Packaging 3 - 22 - B4B					
					Packaging 3 - 23 - B4B					
					Packaging 3 - 24 - B4B					
					Packaging 3 - 25 - B4B					
					Packaging 3 - 26 - B4B					
					Packaging 3 - 27 - B4B					
					Packaging 3 - 28 - B4B					
					Packaging 3 - 29 - B4B					
					Packaging 3 - 30 - B4B					
					Packaging 3 - 31 - B4B					
					Packaging 3 - 32 - B4B					
					Packaging 3 - 33 - B4B					
					Packaging 3 - 34 - B4B					
					Packaging 3 - 35 - B4B					
					Packaging 3 - 36 - B4B					
					140 QC 21 - FG	8 pcs	1/11/19	0.00 0.00	QC 21 - FG - 21	DAG
									QC 21 - FG - 70	21 FEB 14 2019

Part Op **100** - Small Fab-9 (Small Fab) 1- Assemble as per DWG RB23007615 3- ***NOTE Red Barn sticker on sheet #7 N/A as Descriptions: per Eng.

110 - QC5 (QC5- Inspect part completeness to step on W/O)

130 - Packaging3-2 (Identify as per dwg & Stock Location: _____) Identify and Stock

140 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
K206	Flambeau Plastic Box (Clean Out)	8 Ea (1 ea)	100-Small Fab - 1	5127655
PAD210	Foam Ø1 X 1	1.7760 sf (.222 ea)	100-Small Fab - 1	5021250
RB23007615-11	#12 Drill Bit	8 Ea (1 ea)	100-Small Fab - 1	5144373
RB23007615-13	Saw	8 pcs (1 ea)	100-Small Fab - 1	5141755
RB23007615-15	Wire	32 ft (4 ea)	100-Small Fab - 1	5097285
RB23007615-21	Guide	8 pcs (1 ea)	100-Small Fab - 1	5141679
RB23007615-23	Socket Head Cap Screw	24 Ea (3 ea)	100-Small Fab - 1	5144310
RB23007615-25	Strut Checking Gauge	8 pcs (1 ea)	100-Small Fab - 1	5141735
RB23007615-3	#56 Drill Bit	8 Ea (1 ea)	100-Small Fab - 1	5144369
RB23007615-5	#52 Drill Bit	8 Ea (1 ea)	100-Small Fab - 1	5144370
RB23007615-7	#27 Drill Bit	8 Ea (1 ea)	100-Small Fab - 1	5144371
RB23007615-9	#22 Drill Bit	8 Ea (1 ea)	100-Small Fab - 1	5144372

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	K206	8	22	0
	PAD210	2	12	0
	RB23007615-11	8	13	0
	RB23007615-13	8	16	0
	RB23007615-15	32	188	0
	RB23007615-21	8	20	0
	RB23007615-23	24	72	0
	RB23007615-25	8	13	0
	RB23007615-3	8	13	0
	RB23007615-5	8	10	0
	RB23007615-7	8	10	0
	RB23007615-9	8	14	0
Part Specifications				
Specifications could not be found.				

Plex 1/23/19 9:58 AM Dart.Hadley.Shannon



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RB23007615
Job Sheet 186978



Part No: RB23007615

Job Qty: 8 ea

Part Name: Power Turbine Support Cleaning C-30 & C-47



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/23/18

Job Tracking No:

Due Date: 1/11/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB23007615 REV B IPP REV A 18.02.20 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	1/11/19	1/11/19	0.00	0.00	Start Up Small Fab-4		
100	Small Fab	8 pcs	1/11/19	1/11/19	0.00	0.00	Small Fab-9		
110	QC	8 pcs	1/11/19	1/11/19	0.00	0.00	QC5		
130	Packaging	8 pcs	1/11/19	1/11/19	0.00	0.00	Packaging3-2		
140	QC21-FG	8 Ea	1/11/19	1/11/19	0.00	0.00	QC21		

Part Op 100 - 1- Assemble as per DWG RB23007615 3- ***NOTE Red Barn sticker on sheet #7 N/A as per Eng.
Descriptions: 130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
K206	Flambeau Plastic Box (Clean Out)	8 Ea (1 ea)	90-Start up Operation	
PAD210	Foam Ø1 X 1	1.7760 sf (.222 ea)	90-Start up Operation	
RB23007615-11	#12 Drill Bit	8 Ea (1 ea)	90-Start up Operation	
RB23007615-13	Saw	8 Ea (1 ea)	90-Start up Operation	
RB23007615-15	Wire	32 ft (4 ea)	90-Start up Operation	
RB23007615-21	Guide	8 Ea (1 ea)	90-Start up Operation	
RB23007615-23	Socket Head Cap Screw	24 Ea (3 ea)	90-Start up Operation	
RB23007615-25	Strut Checking Gauge	8 Ea (1 ea)	90-Start up Operation	
RB23007615-3	#56 Drill Bit	8 Ea (1 ea)	90-Start up Operation	
RB23007615-5	#52 Drill Bit	8 Ea (1 ea)	90-Start up Operation	
RB23007615-7	#27 Drill Bit	8 Ea (1 ea)	90-Start up Operation	
RB23007615-9	#22 Drill Bit	8 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	K206	8	24	0
	PAD210	2	11	0
	RB23007615-11	8	6	0
	RB23007615-13	8	8	0
	RB23007615-15	32	196	0
	RB23007615-21	8	1	0
	RB23007615-23	24	28	0
	RB23007615-25	8	3	0
	RB23007615-3	8	2	0

RB23007615-5	8	2	0
RB23007615-7	8	2	0
RB23007615-9	8	6	0

Part Specifications

Specifications could not be found.

Plex 11/23/18 12:32 PM Dart.lajeunesse.marie

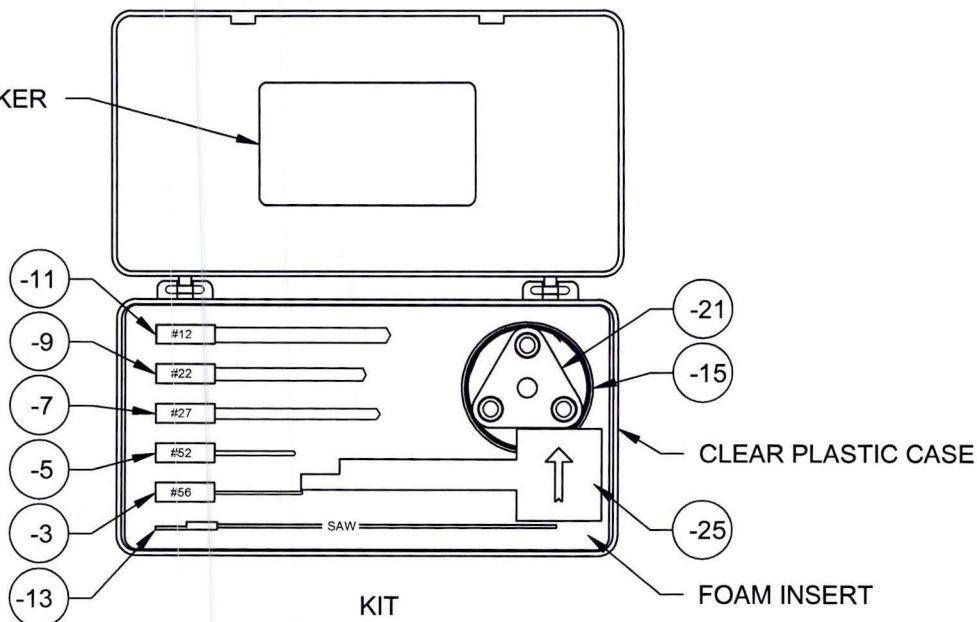
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CH'D TITLE;OCK & REVISION BLOCK, ADDED DWG'S FOR CASE, FOAM INSERT, & ASSY.	8/11/09	RJC	RW
B	-2 ADDED NOTES TO SHEET. -13, -21, -23 MOVED TO SEPARATE SHEETS. -13 CH'D DIMS WAS 6.000 IS 6.00, WAS 12.000 IS 12.00. -21 CH'D DIMS WAS R.300 X3 IS 3X R.30, WAS DRILL & TAP 1/4-28 UNF X3 IS 3X 1/4-28 THRU. ADDED MISSING DIM 2X .344.	2/3/14	DPD	RJC

TEO ATTACHED

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186978 MJS
18-11-23

RED BARN STICKER



ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-2	5	BLOCK	6061	5/16 HEX x 1	2
			-3	1	#56 DRILL BIT		SEE -2 -56 FOR BLOCK METHODS	2
			-5	1	#52 DRILL BIT		SEE -2 -52 FOR BLOCK METHODS	2
			-7	1	#27 DRILL BIT		SEE -2 -27 FOR BLOCK METHODS	2
			-9	1	#22 DRILL BIT		SEE -2 -22 FOR BLOCK METHODS	2
			-11	1	#12 DRILL BIT		SEE -2 -12 FOR BLOCK METHODS	2
			-13	1	SAW		6" LENGTH #HAC5012BX (BESTWAY PRODUCTS)	3
							.050 ROUND x 6 SECTION	
		B/O	-15	4'	WIRE		.041 WRAPPED AROUND 1-7/8 ARBOR	1
			-21	1	GUIDE	6061	Ø2 x 1-1/16	4
			-23	3	SOCKET HEAD CAP SCREWS	STEEL	1/4-28 UNF x 3/8 MODIFIED MCMaster-CARR #91251A435	5
			-25	1	STRUT CHECKING GAGE	6061	.05 x 4-7/8 x 1-1/2	6
		B/O		1	CLEAR PLASTIC CASE		FLAMBEAU #K206 OR EQUIV.	7
		B/O		1	CRAFT FOAM		1 x 4 x 8	7
		B/O		1	RED BARN STICKER		STICKER FACE INSIDE LID FACING OUT	7

RED BARN MACHINE

POWER TURBINE CLEANING KIT

DWG NO. **RB23007615** REV **B**

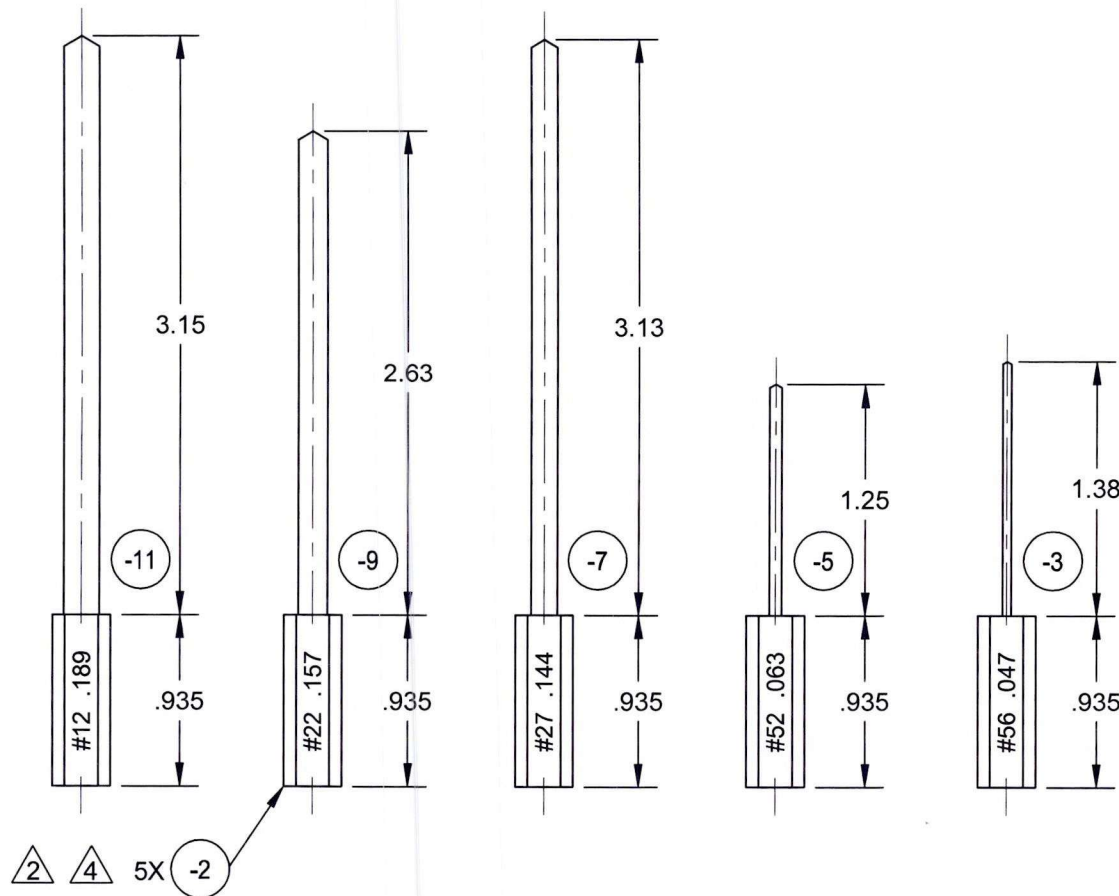
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: CLOUGH
TOLERANCES ON:		APPROVED D. Weil
DECIMALS	XXX ± .005	HEAT
FRACTIONS ± 1/32	XX ± .01	TREAT
ANGLES ± 5°	X ± .1	FINISH
UNLESS OTHERWISE SPECIFIED		SPEC
1. BREAK ALL SHARP EDGES		USED ON MODEL
.015 x 45° PR .015 R		ALLISON C30
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		

SCALE **1:3** DATE **2-1-01** SHEET **1 of 7**

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
B	-2 ADDED NOTES TO SHEET.	2/3/14	DPD

TEO ATTACHED



NOTES:

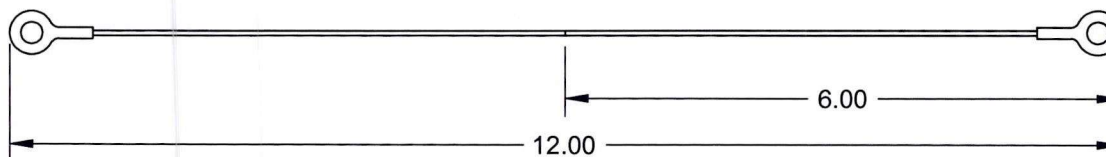
- CHECK EACH HOLE FOR PROPER EXPOSED DRILL LENGTH.
- 2 TO BE DRILLED FOR BIT TO ACHIEVE EXPOSED DRILL LENGTH.
- EPOXY BIT INTO -2 AFTER ANODIZING.
- ANODIZE BLACK MIL-A-8625F, TYPE II, CLASS II

RB RED BARN MACHINE	
TITLE POWER TURBINE CLEANING KIT	
DWG NO. RB23007615-2 THRU -11	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS $\pm 1/32$
XXX $\pm .005$	ANGLES $\pm .5^\circ$
XX $\pm .01$	
X $\pm .1$	
UNLESS OTHERWISE SPECIFIED	
1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 2-1-01
SHEET 2 of 7	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
B	-13 MOVED TO SEPARATE SHEET. CH'D DIMS WAS 6.00 IS 6.00, WAS 12.00 IS 12.00.	2/3/14	DPD	RJC

TEO ATTACHED



NOTE:
CUT EACH HAC5012BX IN HALF EACH
HAC5012BX MAKES SAWS FOR 2 KITS.

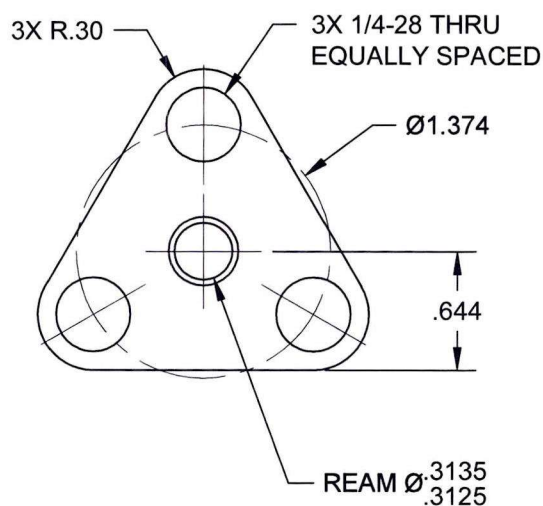
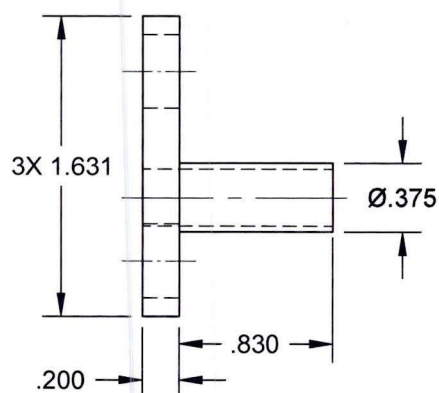
-13
SAW

RED BARN MACHINE	
TITLE POWER TURBINE CLEANING KIT	
DWG NO. RB23007615-13	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: COLE
TOLERANCES ON:	APPROVED <i>D. West</i>
DECIMALS	HEAT
XXX ± .005	TREAT
XX ± .01	FINISH
X ± .1	SPEC
FRACTIONS ± 1/32	USED ON MODEL
ANGLES ± 5°	ALLISON C30
UNLESS OTHERWISE SPECIFIED	
1. BREAK ALL SHARP EDGES	
.015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 2-1-01
SHEET 3 of 7	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
B	-21 ADDED TO SEPARATE SHEET. CH'D DIM TOLERANCE WAS R.300 IS R.30. ADDED NOTE 3X 1/4-28 THRU EQUALLY SPACED. ADDED MISSING DIM .644.	2/3/14	DPD	RJC

TEO ATTACHED



-21

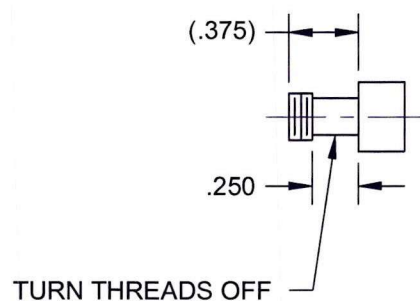
GUIDE

RED BARN MACHINE	
TITLE POWER TURBINE CLEANING KIT	
DWG NO. RB23007615-21	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1	DRAWN BY: COLE APPROVED: <i>D. Weil</i> HEAT TREAT: FINISH: ANODIZE BLACK SPEC: MIL-A-8625F, TYPE II, CLASS II
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL ALLISON C30
SCALE 1:1	DATE 2-1-01 SHEET 4 of 7

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
B	-23 ADDED TO SEPARATE SHEEET.	2/3/14	DPD	RW

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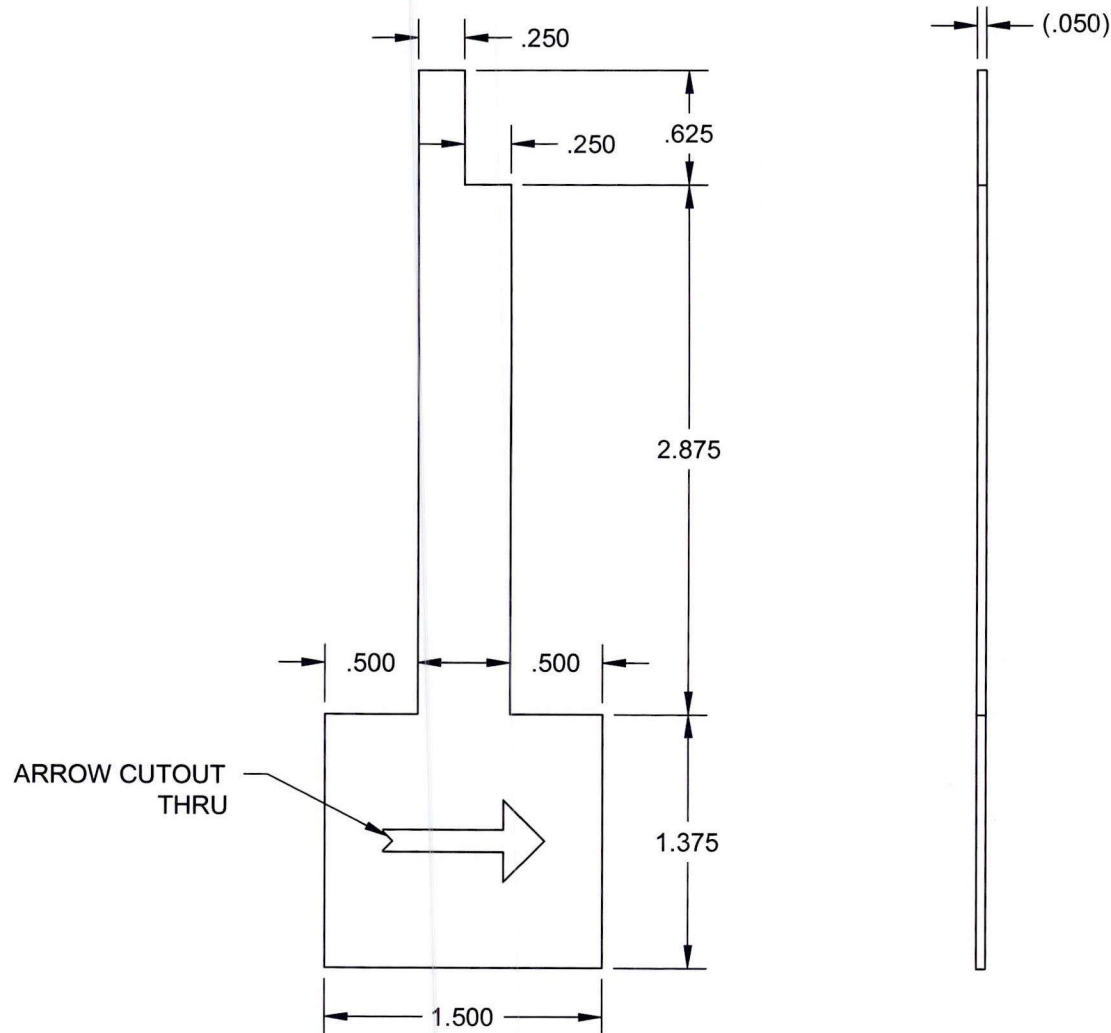
(-23)
MOUNT SCREWS

RED BARN MACHINE	
TITLE POWER TURBINE CLEANING KIT	
DWG NO. RB23007615-23	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS ± 1/32
XXX ± .005	ANGLES ± 5°
XX ± .01	
X ± .1	
UNLESS OTHERWISE SPECIFIED	
1. BREAK ALL SHARP EDGES	
.015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: COLE	
APPROVED: <i>D. Weil</i>	
HEAT TREAT	
FINISH BLACK OXIDE	
SPEC	
USED ON MODEL	
ALLISON C30	
SCALE 1:1	DATE 2-1-01
SHEET 5 of 7	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
B	-25 ADDED WATERJET DXF FILE.	2/3/14	DPD

TEO ATTACHED



-25

STRUT CHECKING GAGE

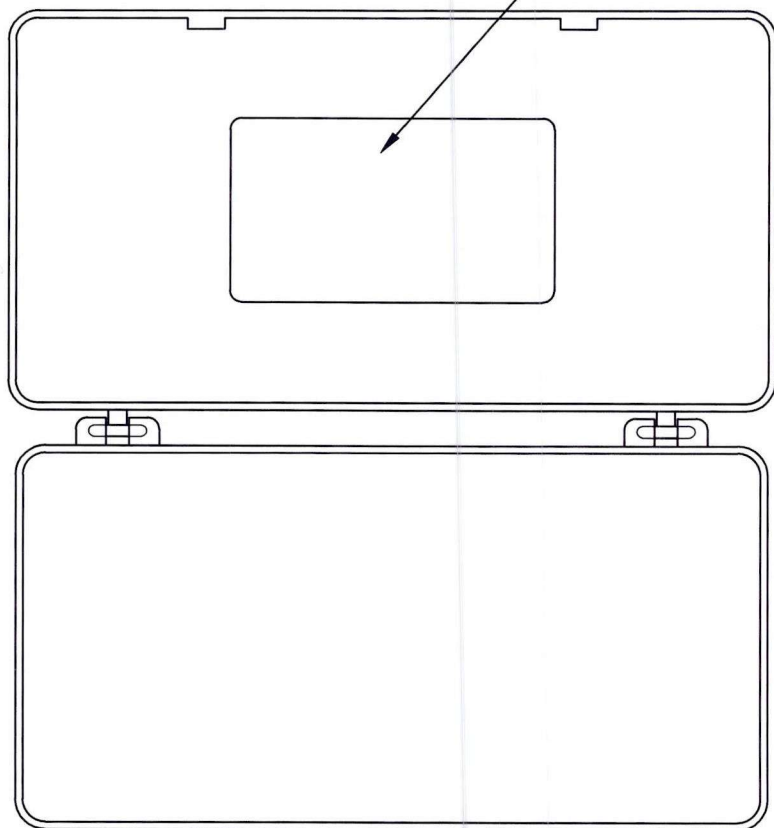
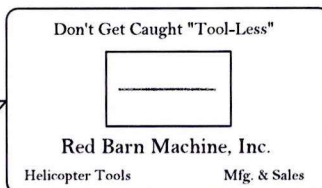
RED BARN MACHINE	
TITLE POWER TURBINE CLEANING KIT	
DWG NO. RB23007615-25	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS ± 1/32
XXX ± .005	ANGLES ± 5°
XX ± .01	
X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: COLE	
APPROVED <i>D West</i>	
HEAT TREAT	
FINISH ANODIZE RED	
SPEC MIL-A-8625F, TYPE II, CLASS II USED ON MODEL	
ALLISON C30	
SCALE 1:1	DATE 2-1-01
SHEET 6 of 7	

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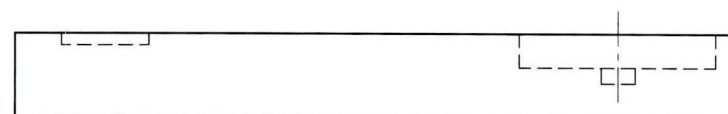
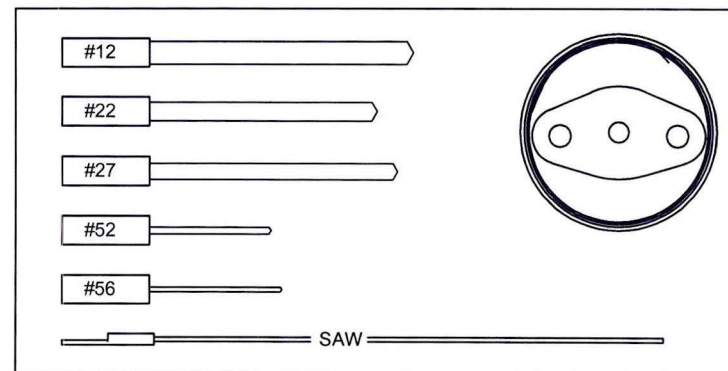
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CH'D TITLE;OCK & REVISION BLOCK, ADDED DWG'S FOR CASE, FOAM INSERT, & ASSY.	8/11/09	RJC	RW

TEO ATTACHED

PLACE STICKER ON INSIDE
FACING OUT



CLEAR PLASTIC CASE



FOAM INSERT

RED BARN MACHINE	
TITLE POWER TURBINE CLEANING KIT	
DWG NO. RB23007615 CASE & INSERT	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS ± 1/32
XXX ± .005	ANGLES ± 5°
XX ± .01	
X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: CLOUGH	
APPROVED: <i>D. Weil</i>	
HEAT TREAT	
FINISH SPEC	
USED ON MODEL	
ALLISON C30	
SCALE 1:2	DATE 2-1-01
SHEET 7 of 7	



ENGINEERING ORDER # TEO17-646

SCALE: NTS

SHEET 1 OF 1

DRAWING NO. RB23007615

REV: B

EFF.: NEXT ORDER

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DATE 17.09.08

TITLE: POWER TURBINE CLEANING KIT

APPROVED: WM 10/03/2017

MFG. APPR.: DP 09/28/2017

CHECKED: SAC 09/28/2017

DRAWN: VM 09/28/2017

TRANSACTION CODE (TC):

A-ADD C-CREATE
R-REVISE D-DELETE

REASON: EPOXY DETAILS MISSING

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WAS : PART# RB23007615-2 THRU -11 Rev B NOTE 3 : EPOXY BIT INTO -2 AFTER ANODIZING

IS : PART# RB23007615-2 THRU -11 Rev B NOTE 3 : LOCTITE CLEAR MULTIPURPOSE INTO -2 AFTER ANODIZING

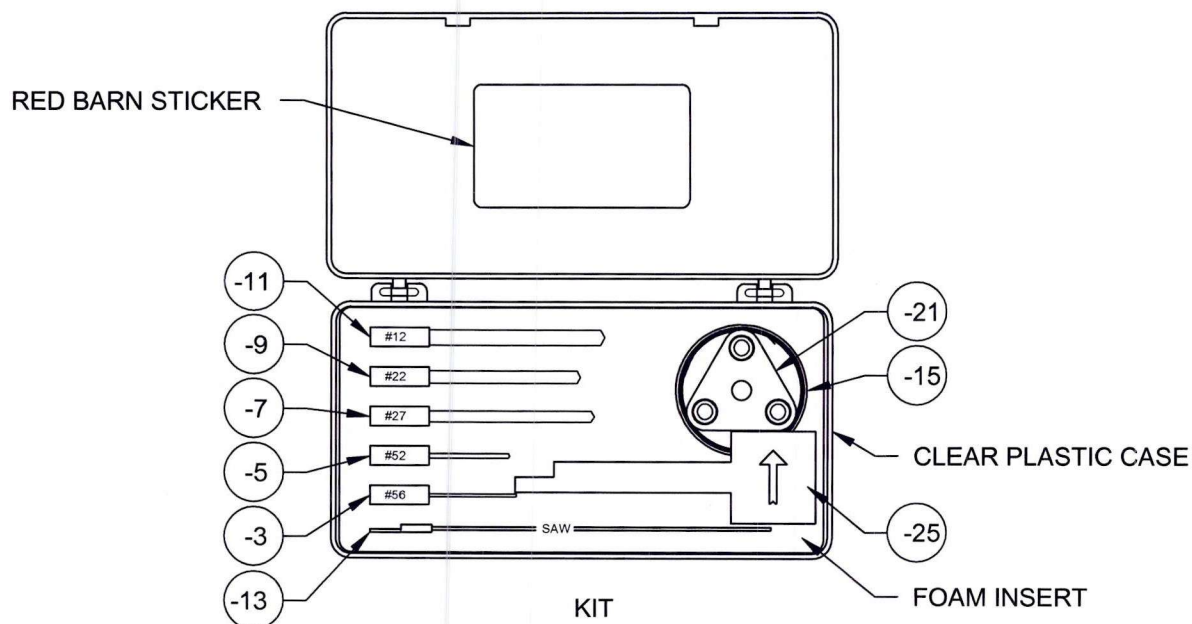
TEO17-646

DOCUMENTS EFFECTED: ☐ PATTERN ☐ INSTALL INSTRUCTIONS ☒ BOM

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CH'D TITLE;OCK & REVISION BLOCK, ADDED DWG'S FOR CASE, FOAM INSERT, & ASSY.	8/11/09	RJC	RW
B	-2 ADDED NOTES TO SHEET. -13, -21, -23 MOVED TO SEPARATE SHEETS. -13 CH'D DIMS WAS 6.000 IS 6.00, WAS 12.000 IS 12.00. -21 CH'D DIMS WAS R.300 X3 IS 3X R.30, WAS DRILL & TAP 1/4-28 UNF X3 IS 3X 1/4-28 THRU. ADDED MISSING DIM 2X .344.	2/3/14	DPD	RJC

TEO ATTACHED



ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-2	5	BLOCK	6061	5/16 HEX x 1	2
			-3	1	#56 DRILL BIT		SEE -2 -56 FOR BLOCK METHODS	2
			-5	1	#52 DRILL BIT		SEE -2 -52 FOR BLOCK METHODS	2
			-7	1	#27 DRILL BIT		SEE -2 -27 FOR BLOCK METHODS	2
			-9	1	#22 DRILL BIT		SEE -2 -22 FOR BLOCK METHODS	2
			-11	1	#12 DRILL BIT		SEE -2 -12 FOR BLOCK METHODS	2
			-13	1	SAW		6" LENGTH #HAC5012BX (BESTWAY PRODUCTS)	3
							.050 ROUND x 6 SECTION	
		B/O	-15	4'	WIRE		.041 WRAPPED AROUND 1-7/8 ARBOR	1
			-21	1	GUIDE	6061	Ø2 x 1-1/16	4
			-23	3	SOCKET HEAD CAP SCREWS	STEEL	1/4-28 UNF x 3/8 MODIFIED MCMaster-CARR #91251A435	5
			-25	1	STRUT CHECKING GAGE	6061	.05 x 4-7/8 x 1-1/2	6
		B/O		1	CLEAR PLASTIC CASE		FLAMBEAU #K206 OR EQUIV.	7
		B/O		1	CRAFT FOAM		1 x 4 x 8	7
		B/O		1	RED BARN STICKER		STICKER FACE INSIDE LID FACING OUT	7
ASSY #								

RED BARN MACHINE	
POWER TURBINE CLEANING KIT	
TITLE	REV
DWG NO.	B
RB23007615	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS ± 1/32
XXX ± .005	ANGLES ± 5°
XX ± .01	
X ± .1	
UNLESS OTHERWISE SPECIFIED	
1. BREAK ALL SHARP EDGES	
.015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: CLOUGH	
APPROVED: <i>D Weil</i>	
HEAT TREAT FINISH SPEC	
USED ON MODEL	
ALLISON C30	
SCALE	DATE
1:3	2-1-01
SHEET	1 of 7